

NCP-19-7755



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2574**Job Sheet 192899****Part No:** D2574**Job Qty:** 16 pcs**Part Name:** Saddle, Aft, In**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/3/19**Job Tracking No:****Due Date:** 5/1/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:** *order 14605***Note:** DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM**Ship Via:****Bill of Materials***90 Issue SIN**Heres***Job Routing***SBL 19/05/02*

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	16 pcs	5/1/19	1.21	25.00	HAAS - 1		SBL 19/05/07	
						HAAS - 2			
						HAAS - 3			
						HAAS - 4			
110	Conventional Mill - 1 - B4B	16 pcs	5/1/19	0.00	2.00	Conventional Mill - 1 - B4B		SBL 19/05/07	
						Conventional Mill - 2 - B4B			
120	QC 2	16 pcs	5/1/19	0.00	0.00	QC 2 - 1			
						QC 2 - 12			
						QC 2 - 14			
						QC 2 - 17			
						QC 2 - 19			
						QC 2 - 2			
						QC 2 - 20			
						QC 2 - 22			
						QC 2 - 23			
						QC 2 - 25			
						QC 2 - 32			
						QC 2 - 33			
						QC 2 - 35			
						QC 2 - 39			
QC 2 - 4									
QC 2 - 40									
QC 2 - 44									
QC 2 - 45									
QC 2 - 48									
QC 2 - 49									
QC 2 - 50									
QC 2 - 51									
QC 2 - 52									
QC 2 - 56									



Dart Aerospace Ltd.
1270 Aberdeen Street
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Container No: S177312**Part:** D2574**Job No:** 192899**Serial No/Batch:** S177312**Revision:** Rev.F**Inspector:****Exp Date:****Instructions:** D2574 Rev C, sheets 1-3 *Date: 05/02/19*

P.T.O.

130	QC 8	16 pcs	5/1/19	0.00	0.00	QC 2 - 57	SBL 19/05/07
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 8 - 12	
						QC 8 - 14	DR 19/05/08
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
140	Handfinish - 1-1 Chemical-B4B	16 pcs	5/1/19	0.00	0.64	QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	D.R 19/05/09
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	

				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	16 pcs	5/1/19	0.00 0.52	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	16 pcs	5/1/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
170	Packaging 3-1 - Stock - B4B	16 pcs	5/1/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B

BR 19-5-9

DAS
MAY 09 2019 40
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MAY 09 2019

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	16 pcs	5/1/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	21
					QC 21 - SA - 53	21

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. 177312 1-Machine Step No 1 per Folio FA051 and inspect
 Descriptions: per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	16 pcs (1 ea)	100-HAAS 4 Axis	<u>SIC6590</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-005	16	72	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Aft Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Aft Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Aft Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Aft Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Aft Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Aft Inboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Aft Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Aft Inboard	1.365Inches + 0.010 - 0.000	1.375 1.365		
14	Saddle, Aft Inboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Aft Inboard	4.119Inches + 0.010 - 0.000	4.129 4.119		
16	Saddle, Aft Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
17	Saddle, Aft Inboard	0.115Inches + 0.020	0.135		

			- 0.000	0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

Plex 4/3/19 1:16 PM Dart.lajeunesse.marie

DART AEROSPACE LTD	Work Order: 192 599	
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	7.999		
F	0.490	0.510		.500	0.498	0.500	0.503		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.500	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.125	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	0.130		
Q	0.115	0.135		.125	.125	.126	.125		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.132	.127	.130	0.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.242	.242	0.241		
W	0.115	0.135		.132	0.133	0.130	0.129		
X	0.307	0.312		.311	0.311	0.310	0.310		
Y	0.760	0.765		.760	0.760	0.760	0.760		
Z	0.352	0.372		.362	0.362	0.363	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	0.6235	0.623	0.623		
AC	0.053	0.073		.066	.064	.066	.064		
AD	0.240	0.260		.251	.252	.252	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.133	.128	.130	0.130		
AG	0.240	0.280		.265	.265	.265	0.265		
AH	0.240	0.260		.252	.251	.252	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBC	VH
Date: 19/05/08	19/05/08

Audited by: MK
Date: 19/05/08

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 192 899	
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#5	20	37	48		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	8.000		
F	0.490	0.510		0.501	0.500	0.502	0.503		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.375	0.375	0.375		
I	0.490	0.510		0.5025	0.500	0.499	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5695	0.568	0.568	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.132	0.132	0.132	0.131		
Q	0.115	0.135		0.125	0.125	0.126	0.126		
R	0.240	0.260		0.251	0.251	0.251	0.252		
S	0.115	0.135		0.130	0.130	0.130	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.243	0.2405	0.242	0.247		
W	0.115	0.135		0.130	0.130	0.129	0.130		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.624	0.624	0.624		
AC	0.053	0.073		0.067	0.067	0.065	0.063		
AD	0.240	0.260		0.253	0.251	0.251	0.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.250	0.251	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: 936	Audited by: [Signature]
Date: 19/05/03	Date: 19/05/08

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 192849
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.499	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.566	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.250	0.253	0.252	0.252		
S	0.115	0.135		0.130	0.130	0.131	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.241	0.243	0.242		
W	0.115	0.135		0.130	0.130	0.129	0.132		
X	0.307	0.312		0.311	0.310	0.310	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.252	0.253	0.253		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.252	0.253	0.256	0.255		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 19/5/16	Date: 19/05/08

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 192 889
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	113	214	315	416	By	Date
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1750	1750	1750	1750		
C	3.495	3.505		3500	3500	3500	3500		
D	1.745	1.755		1750	1750	1750	1750		
E	7.990	8.010		7999	7999	7999	7999		
F	0.490	0.510		500	500	499	500		
G	0.257	0.262		258	258	258	258		
H	0.375	0.380		375	375	375	375		
I	0.490	0.510		500	500	500	500		
J	1.174	1.184		1179	1179	1179	1179		
K	0.558	0.578		568	568	568	568		
L	1.174	1.184		1179	1179	1179	1179		
M	1.365	1.375		1370	1370	1370	1370		
N	2.495	2.505		2500	2500	2500	2500		
O	4.119	4.129		4124	4124	4124	4124		
P	0.115	0.135		133	132	128	130		
Q	0.115	0.135		125	125	120	120		
R	0.240	0.260		252	254	255	255		
S	0.115	0.135		130	132	130	131		
T	0.178	0.198		188	188	188	188		
U	3.210	3.250		3230	3230	3230	3230		
V	0.230	0.250		241	241	241	241		
W	0.115	0.135		132	132	132	132		
X	0.307	0.312		311	311	311	311		
Y	0.760	0.765		760	760	760	760		
Z	0.352	0.372		364	363	363	363		
AA	0.470	0.530		500	500	500	500		
AB	0.615	0.635		623	622	622	622		
AC	0.053	0.073		667	664	666	667		
AD	0.240	0.260		251	255	254	255		
AE	1.500	1.520		1510	1510	1510	1510		
AF	0.115	0.135		133	133	132	132		
AG	0.240	0.280		250	250	250	250		
AH	0.240	0.260		250	254	254	254		
AI	2.000	2.020		2000	2000	2000	2000		
AJ	0.023	0.043		033	033	033	033		
Accept/Reject									

Measured by: SBL
Date: 19/05/07

Audited by: [Signature]
Date: 19/05/08

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]

Entered: LR Date: Nov 19/11



NCR No. 19-7755

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>192899</u> Part No. <u>D2574</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date : <u>19/5/11</u>		Sequence #: <u>110</u>		QTY Affected : <u>①</u>		MRB (QSI042) <u>1 MSP 12 4/19/11</u>																													
Description Work Order Deviation Part was buffed on inner flange to remove tool impact mark. Approx 1" long region near bore affected.				Disposition Acceptable. Local thinning will not affect fit or strength.		Completed By <u>[Signature]</u> 12/5/11 Lead hand / Supervisor <u>[Signature]</u> 19/05/08 QC / QA Coordinator <u>[Signature]</u> 19-05-11																													
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☒ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☒ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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